

# Work Order ID 121329

June-24-14 1:59:42 PM

**\*121329\***

Page 1

Item ID: D4695-3 **D 4 6 9 5 - 3** Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: **B 1 2 1 3 2 9** Stop **\*NS2\***  
 Item Name: Channel  
 Start Date: 6/24/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 6/27/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr/</b>	<b>Revision Nbr</b>								
D4695	B								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00				10	EL	14-6-25	
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00				10	Q	14-6-25	
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89

2B  
14/6/25

10

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Item ID: D4695-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Channel  
 Start Date: 6/24/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 6/27/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		10			14/6/25
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 27 9-89		10			14/6/25
160 <b>*160*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10			14/6/26

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**\*121329\***

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Item ID: D4695-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Channel

Start Date: 6/24/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 6/27/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours DAS	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				10			
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00 0.00				10X		14-7-01	SP
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				MLJ		14-07-02	ME 14-7-01

# Picklist Print

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Work Order ID: 121329

**\*121329\***

Parent Item: D4695-3

**\*D4695-3\***

Parent Item Name: Channel

Start Date: 6/24/14

Required Date: 6/27/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

423.9200

10

**\*M6061T6S 040\***

6061-T6 .040 Sheet

**\*\***

EL 14625

Location

Loc Qty

Loc Code

MAT021

423.92

m126350

19.52

m126981

76.91

m128422

49.79

m129165

85.7

m129584

192

10

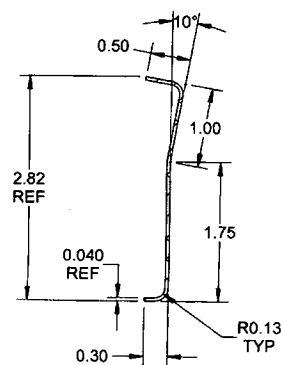
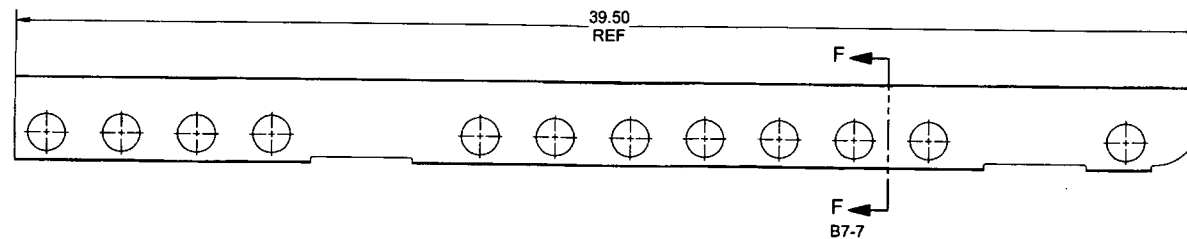
DART AEROSPACE LTD		Work Order:	124329
Description: Channel		Part Number:	D4695-3
Inspection Dwg: D4695      Rev: B			Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	EL	Audited by:	EB 27	Preliminary Approval:	
Date:	14-6-25	Date:	14/6/25	Date:	

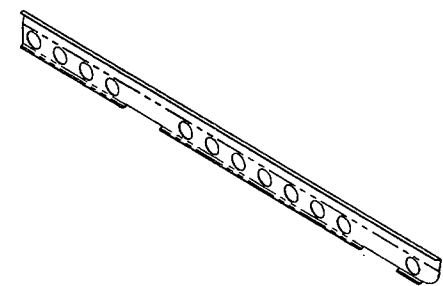
Rev	Date	Change	Revised by	Approved
A	13.03.07	New Issue	KJ	
B	13.04.12	Dwg Rev updated	KJ	



**SECTION F-F C4-7**

**D4695-3 CHANNEL**

*WLB  
121329*

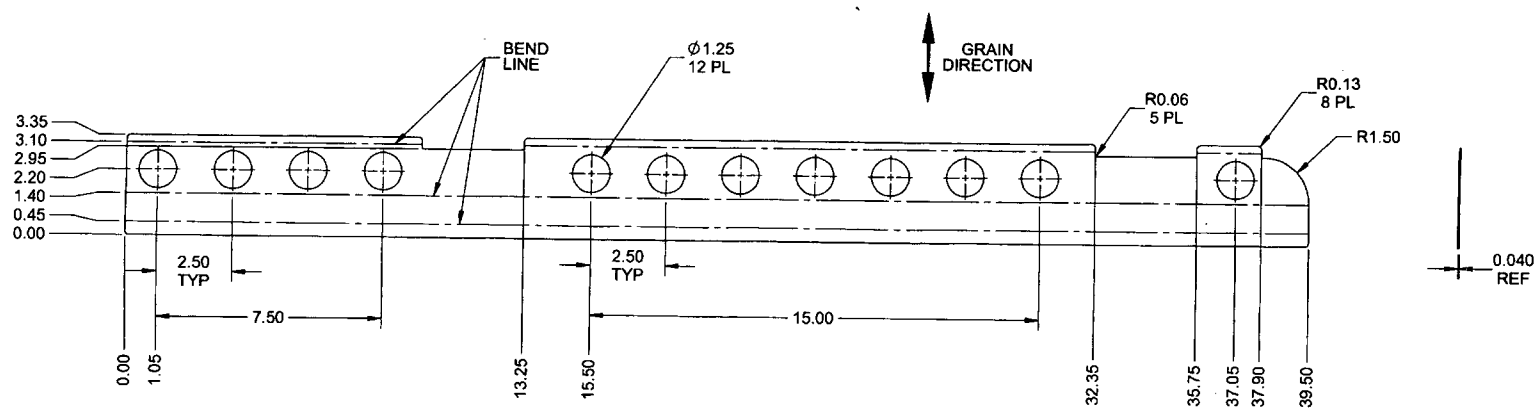


**NOTES:**

- 1) MATERIAL: MAKE FROM D4695-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.44 lbs

**RELEASE**  
2013-04-02

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ST</i>	<b>D4695</b>	SHEET 7 OF 12
APPROVED	<i>ST</i>	TITLE	SCALE
DE APPR.	<i>ST</i>	<b>CHANNEL ASSEMBLY</b>	NTS
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**D4695-3F FLAT PATTERN CHANNEL**

**RELEASED**  
2013-04-02

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.44 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	AT	<b>D4695</b>	SHEET 9 OF 12
APPROVED	MC	TITLE	SCALE
DE APPR.	MC	<b>CHANNEL ASSEMBLY</b>	NTS
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